

Work Order ID 124320

124320

September-16-14 1:25:46 PM

Page 1

Item ID: D2432-3 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: 206 (24") Bearpaw Stop *NS2*

Start Date: 9/10/14 Start Qty: 2.00 *2*

Required Date: 9/10/14 Req'd Qty: 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	H

105 0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 25836
Cut Blanks per D2432-3

CX 14/10/18 2

115 Receive & Inspect for Damage & Mat'l Certs 0.00

115

Packaging

Memo

0.00

Packaging

14/10/18 (2)

125 QC6- Inspect dimensions to drawing 0.00

125

QC

Memo

0.00

Quality Control

14/10/27 2 18

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Item ID: D2432-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 (24") Bearpaw
 Start Date: 9/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	0.00 0.00	 14/10/28			2			
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2			
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	 14/10/27			2			SL14-10-28

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Item ID: D2432-3 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: 206 (24") Bearpaw
 Start Date: 9/10/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>12405</u>	0.00				<u>21</u>			
160									
Packaging	Memo	0.00							
Packaging									DAS 06 8-09
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									<u>MLD</u> <u>15-02-04</u> <u>mk</u> <u>15-2-3</u>

Picklist Print

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Page 1

Work Order ID: 124320

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Parent Item: D2432-3

D2432-3

Parent Item Name: 206 (24") Bearpaw

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A AS PER REV G 12-07-24 JLM VERIFIED BY:DD IPP
REV:B 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	401.0000	3.7	8			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CY 19/10/03

Location

Loc Qty

Loc Code

MAT014

401

m128267

47

m128668

297.3

m129293

56.7

TPE

m130421 48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	124320
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

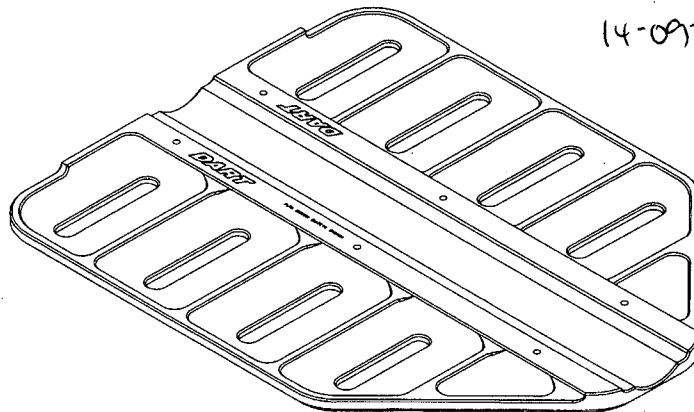
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	.063	✓		Vertical line with checkmark at bottom	
5.500	+/-0.030	5.502	✓			
0.200	+/-0.030	N/A				
0.25 x 45°	+/-0.030	.230	✓			
R0.250	+/-0.030	.250	✓			
0.250	+/-0.010	.255	✓			
0.625	+/-0.030	.630	✓			
0.380	+0.030/-0.010	.386	✓			
0.950	+0.030/0.010	.963	✓			
19.000	+/-0.030	19.00	✓			
3.14	+/-0.030	N/A				
3.28	+/-0.030	N/A				
Ø0.260	+0.005/-0.000	.260	✓			
Ø0.93	+/-0.030	.930	✓			
0.30	+0.030/-0.000	.310	✓			
23.750	+/-0.030	23.750	✓			
4.250	+/-0.010	4.250	✓			
2.000	+/-0.030	2.022	✓			
9.000	+/-0.010	9.00	✓			
9.000	+/-0.010	9.00	✓			
0.380	+/-0.030	.382	✓			

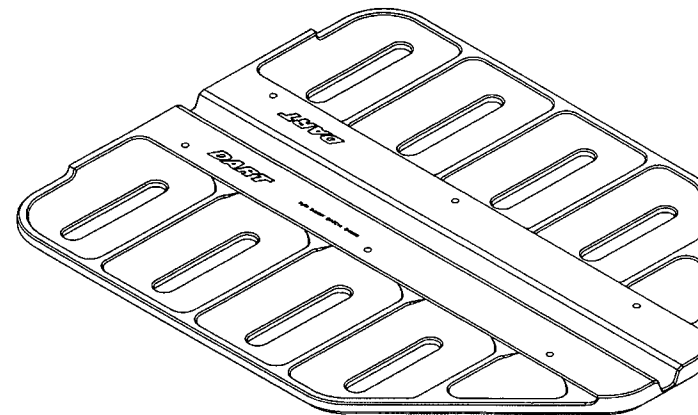
Measured by:	P/H/10/27	Audited by:	SL	Preliminary Approval:	
Date:		Date:	14-10-28	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	MA

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ONLY
 NO 124320 MJS
 14-0976



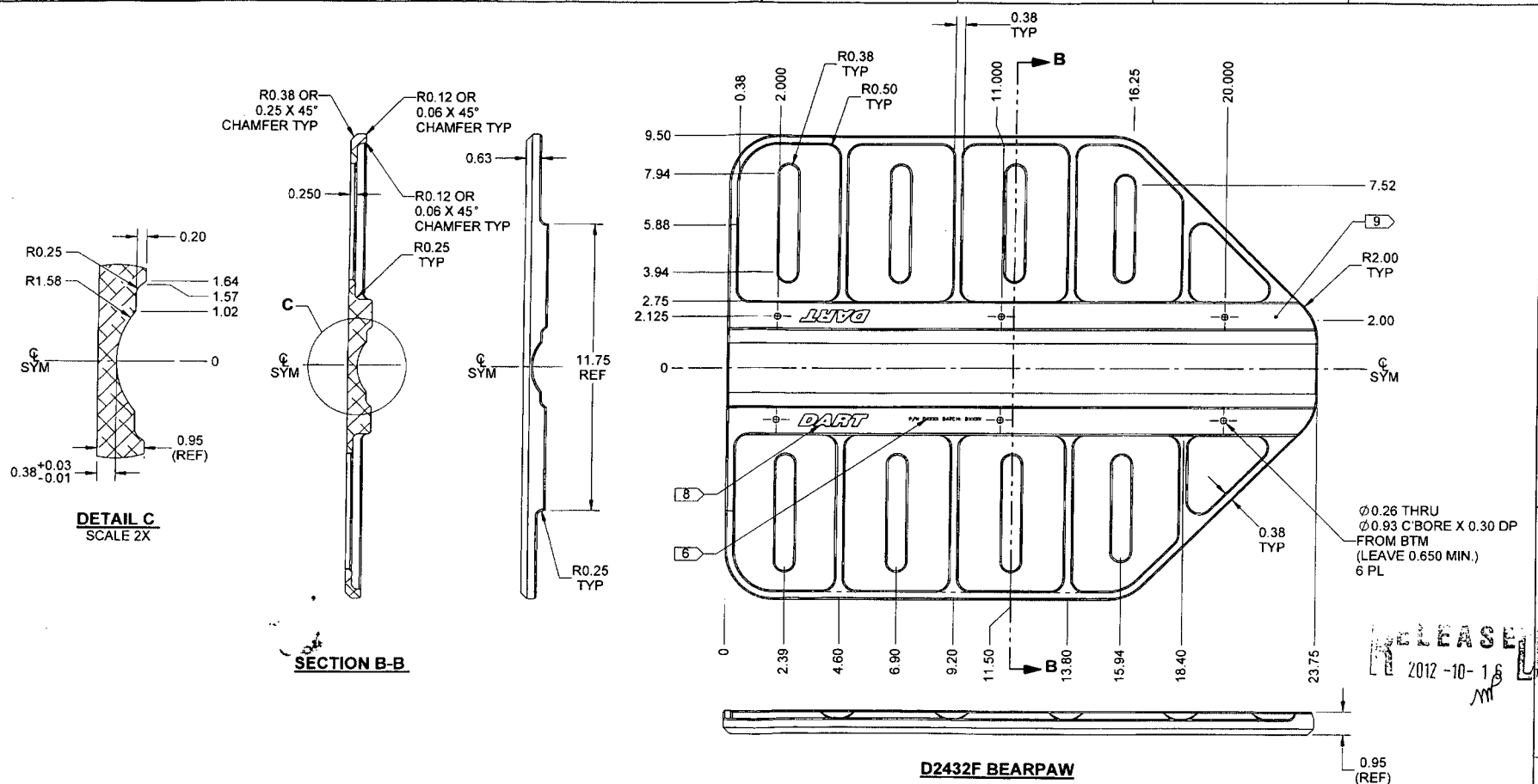
D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
 2012-10-16

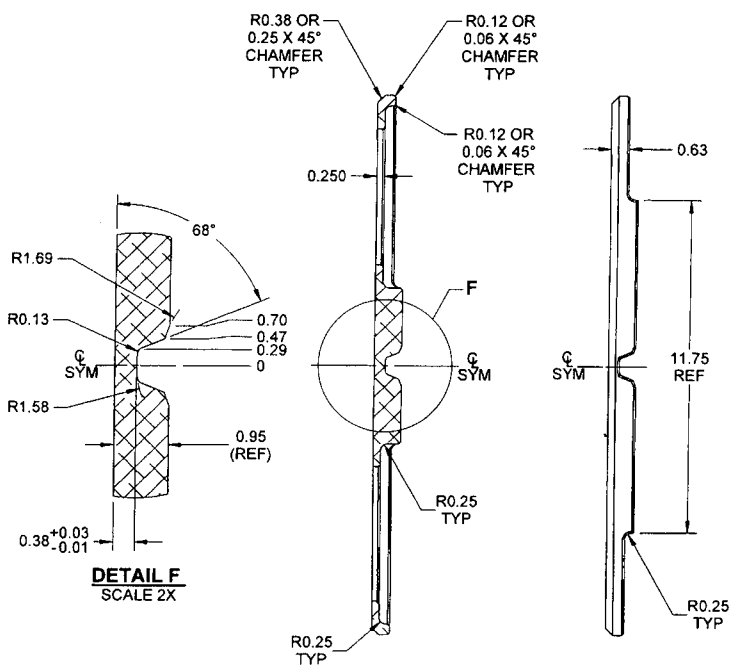
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.28
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	AP	D2432	SHEET 1 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



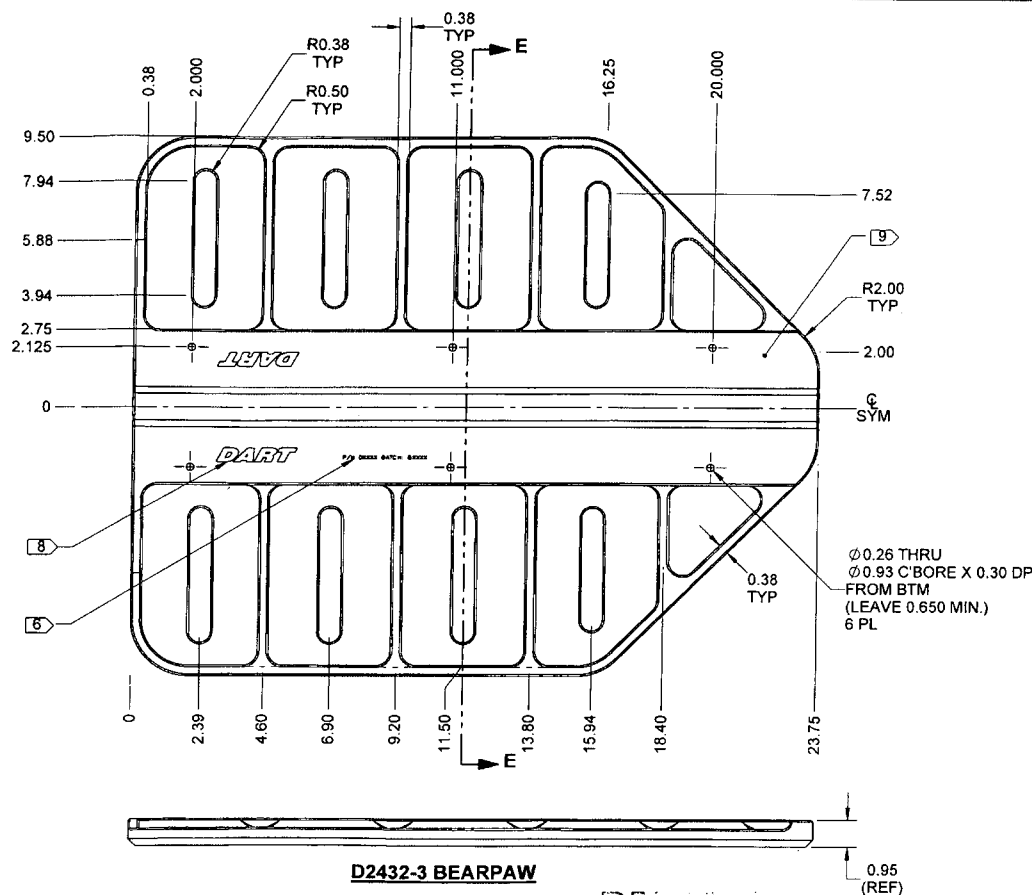
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	ST	D2432	SHEET 2 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	ST	BEARPAW	NTS
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SECTION E-E



D2432-3 BEARPAW

RELEASED
2012-10-16

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	BEARPAW	NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.:

6316

Date:

2014-09-29

Page:

1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2
		d2521-30	
Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			